

Work Order ID 83479

April-18-12 2:41:50 PM

83479

Page 1

Item ID: D4095-043

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Wearplate Assembly

Start Date: 18/04/2012 Start Qty: 8.00

8

Cust Item ID:

Required Date: 02/05/2012 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/04/18 Tooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4095

B

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg (D4095-3)

Dwg Rev: B

Prog Rev: B

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

B12-426

B12-426

Szklacz

8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

Item ID: D4095-043
 Revision ID:
 Item Name: Wearplate Assembly
 Start Date: 18/04/2012 Start Qty: 8.00
 Required Date: 02/05/2012 Req'd Qty: 8.00
 Reference:

Accept

N900040100

Setup Start ***NS1***
 Stop ***NS2***

Cust Item ID:
 Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	NC BRAKE					(8)			SB nloska
Brake NC	Memo	0.00							
Brake NC	1- bend section C-C first 2- Form on Brake as per Dwg D4095 using Jigs DT 8179 and DT 8155 3- Form Joggles (2) as per Dwg D4095 on brake using Jig DT 8157								
140		0.00							
140	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.00				(8)			
Quality Control	Ensure joggle as per dwg D4095								
150		0.00							
150	Weld per dwg A/R Hardcoat S.S. Batch: <u>11102030</u>								
Large Fab	Large Fab								
Large Fab	Memo	0.00				(8)			12-6-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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83479

Page 4

April-18-12 2:41:50 PM

Item ID: D4095-043
Revision ID:
Item Name: Wearplate Assembly

Accept

N900040100

Setup Start ***NS1***

Stop ***NS2***

Start Date: 18/04/2012 Start Qty: 8.00

8

Cust Item ID:

Required Date: 02/05/2012 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC3- Inspect Part Finish	0.00							
190									
QC	Memo	0.00				8		12/6/22	
Quality Control									
200	Identify as per dwg & Stock Location	0.00							
200									
Packaging	Memo	0.00				82		12/6/22	
Packaging									
210	QC21- Final Inspection - Work Order Release	0.00							
210									
QC	Memo	0.00						MCJ 12/06/22	
Quality Control									

MCJ 12/06/22

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April-18-12 2:41:53 PM

Page 1

Work Order ID: 83479

83479

Parent Item: D4095-043

D4095-043

Parent Item Name: Wearplate Assembly

Start Date: 18/04/2012

Required Date: 02/05/2012

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A new issue DD 10.04.26 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	180.6520	2.275	19.15789			

M304S16GA

304/316 Sheet .063

**

B12-4-22

Location

Loc Qty

Loc Code

MAT020

180.652

120866

30.446

120877

137.326

121070

12.88

120877

8

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DART AEROSPACE LTD		Work Order:	03479
Description: Wearplate		Part Number:	D4095-3
Inspection Dwg: D4095 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.19	+0.005/-0.001	190	2		✓ BoZ	
0.300	+/-0.010	300	✓		✓	
0.300	+/-0.010	301	✓		✓	
2.432	+/-0.010	2.441	✓		✓	
3.227	+/-0.010	3.220	2		✓	
4.06	+/-0.030	4.061	2		✓	
2.50	+/-0.030	2.500	2		✓	
4.98	+/-0.030	4.980	2		✓ BoZ	
8.43	+/-0.030	8.427	2		✓	
11.50	+/-0.030	11.50	2		✓	
21.750	+/-0.010	21.750	✓		✓	
3.500	+/-0.010	3.500	✓		✓	
12.22	+/-0.030	12.22	2		✓	
6.000	+/-0.010	6.000	✓		✓	
12.100	+/-0.010	12.100	✓		✓	
21.00	+/-0.030	21.00	✓		✓	
30.000	+/-0.010	30.00	✓		✓	
36.000	+/-0.010	36.00	✓		✓	
38.88	+/-0.030	38.88	✓		✓	
0.063	+/-0.010	0.059	2		✓	

Measured by:	JB
Date:	12-4-26

Audited by:	S
Date:	12/4/26

Preliminary Approval:	
Date:	

Rev	Date	Change	Revised by	Approved
A	11.02.18	New Issue P/O D4095-043	KJ	
B	11.11.08	Dimensions updated per Dwg Rev B	KJ	

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

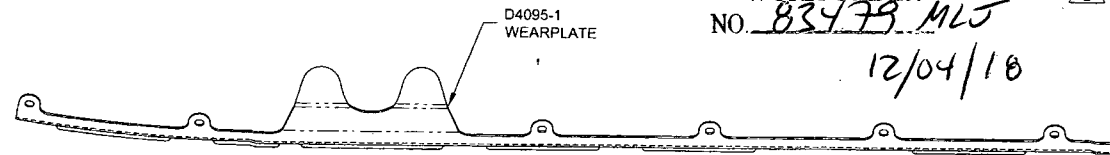
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

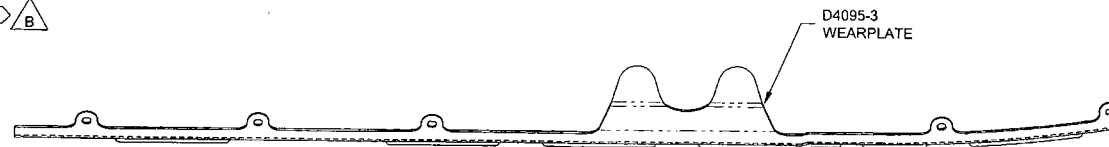
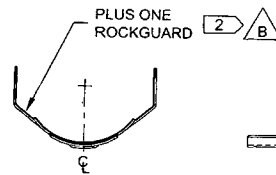
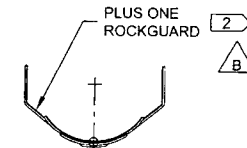
NOTE: Date & initial all entries

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 83479 MLJ
12/04/10

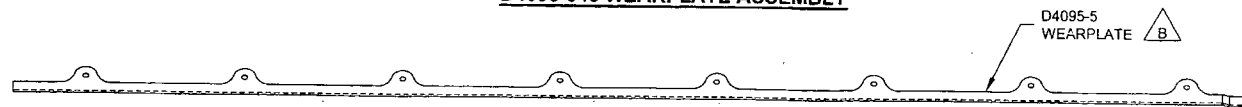
ITEM	QTY -041	QTY -043	QTY -045	QTY -047	QTY -049	QTY -051	PART NUMBER	DESCRIPTION
1	X						D4095-041	WEARPLATE ASSEMBLY
2		X					D4095-043	WEARPLATE ASSEMBLY
3			X				D4095-045	WEARPLATE ASSEMBLY
4				X			D4095-047	WEARPAD ASSEMBLY
5					X		D4095-049	WEARPAD ASSEMBLY
6						X	D4095-051	WEARPAD ASSEMBLY
7	1						D4095-1	WEARPLATE
8		1					D4095-3	WEARPLATE
9			1				D4095-5	WEARPLATE
10				1			D4095-7	WEARPAD
11					1		D4095-9	WEARPAD
12						1	D4095-11	WEARPAD
13	A/R	A/R	A/R	A/R	A/R	A/R	4715 (4714)	PLUS ONE ROCKGUARD BLACK (TAN)



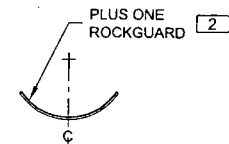
D4095-041 WEARPLATE ASSEMBLY



D4095-043 WEARPLATE ASSEMBLY



D4095-045 WEARPLATE ASSEMBLY



D4095-041/-043/-045/-047/-049/-051 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: COAT ENTIRE TOP (CONCAVE) SURFACE WITH PLUS ONE ROCKGUARD 4714 OR 4715, 0.02-0.04 THICK
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4095-0XX" AND B/N "BXXXXX" USING REMOVABLE TAG PER QSI 044 6.6
- 7) WEIGHT: D4095-041 = 3.08 lbs; D4095-043 = 3.08 lbs; D4095-045 = 2.00 lbs; D4095-047 = 0.48 lbs; D4095-049 = 0.42 lbs; D4095-051 = 0.37 lbs
- 8) PARTS ARE SYMMETRIC ABOUT C

B	REVISED D4095-1/-1F/3/3F: 4715 PLUS ONE ROCKGUARD REPLACES D4096-1/-3; ADDED D4095-5/-7 -9/-11; REVISED HARDCOAT DESIGN; REVISED NOTE 2	XDF	11.10.18
A	NEW ISSUE	MB	10.04.20
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN	XDF		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.10.18		

DART AEROSPACE USA, INC
KENT, WA
DRAWING NO. D4095
TITLE WEARPLATE
REV. B
SHEET 1 OF 8
SCALE
NTS

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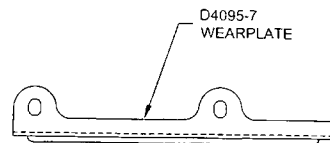
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

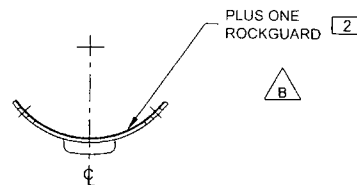
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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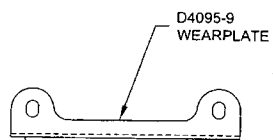
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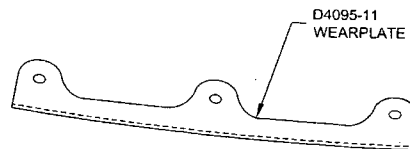
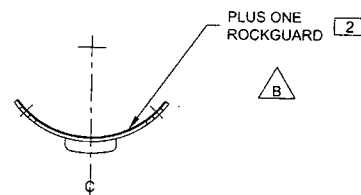
D4095-047 WEAR PAD ASSEMBLY



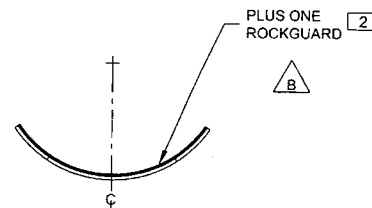
83479



D4095-049 WEAR PAD ASSEMBLY



D4095-051 WEARPAD ASSEMBLY



RELEASED
2011-10-31

DESIGN	18	DART AEROSPACE USA, INC	
DRAWN	XDF	KENT, WA	
CHECKED	10	DRAWING NO.	REV. B
MFG. APPR.	10	D4095	SHEET 2 OF 6
APPROVED	10	TITLE	SCALE
DE APPR.	10	WEARPLATE	NTS
DATE	11.10.18	<small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

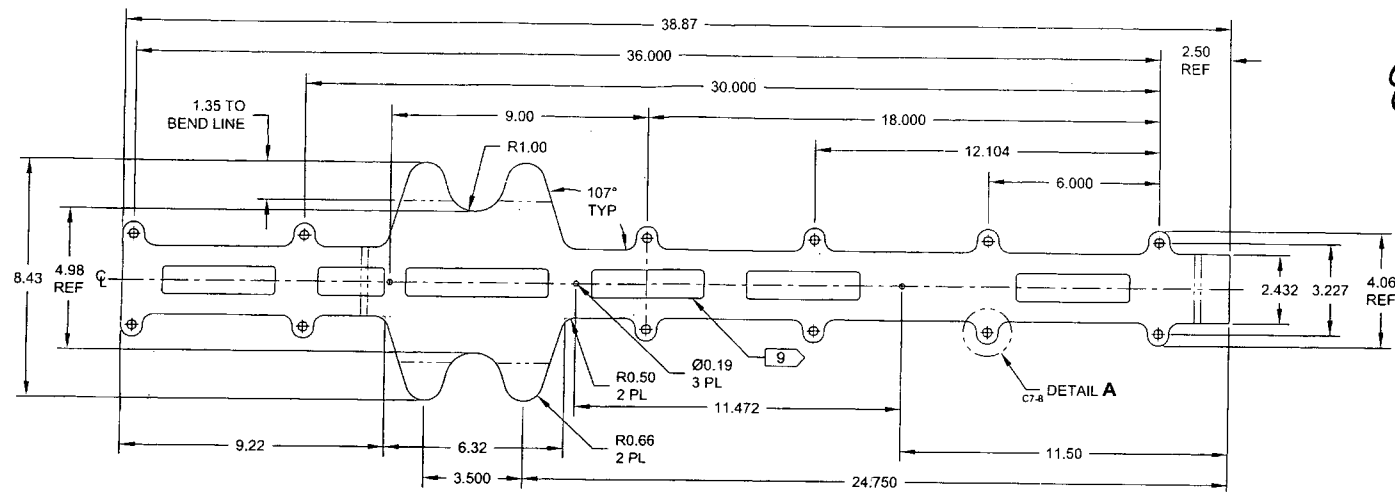
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

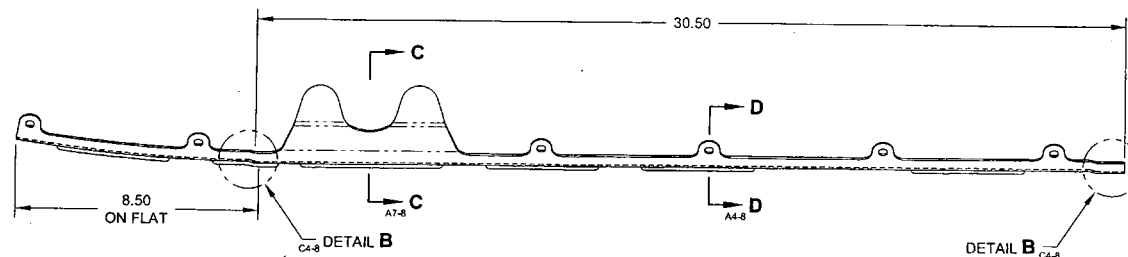
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4095-1F FLAT PATTERN 1



D4095-1 BENDING DETAIL
(MAKE FROM D4095-1F)

D4095-1/-1F/-3/-3F/-5/-5F/-7/-7F/-9/-9F/-11/-11F NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET ANNEALED 2B FINISH, 16 GAUGE (0.063 THICK)
PER AMS 5513 (304) OR AMS 5524 (316), OR ASTM A240 OR ASME SA240
REF DART MATERIAL SPEC M304S16GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D4095-1 = 3.00 lbs; D4095-3 = 3.00 lbs; 4095-5 = 1.96 lbs; D4095-7 = 0.47 lbs; D4095-9 = 0.41 lbs; D4095-13 = 0.36 lbs
- 8) WELDING: PER DART QSI 004
- 9) PARTS ARE SYMMETRIC ABOUT C

DESIGN		DART AEROSPACE USA, INC	
DRAWN	XDF	KENT, WA	
CHECKED	10	DRAWING NO.	REV. B
MFG APPR.	10	D4095	SHEET 3 OF 8
APPROVED	10	TITLE	SCALE
DE APPR.	10	WEARPLATE	NTS
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2011-10-31

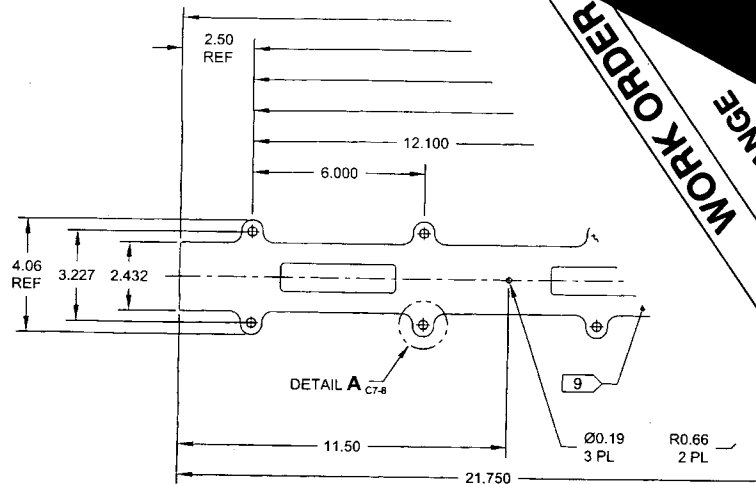
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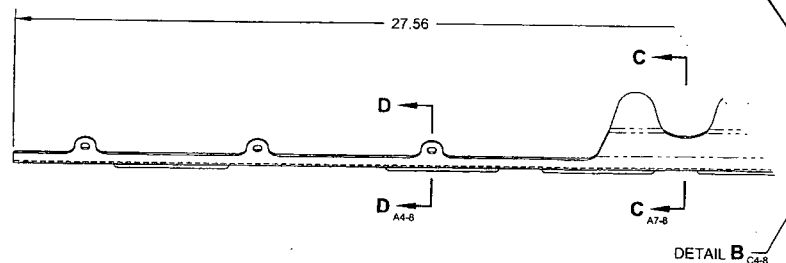
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D4095-3F FLAT PA.



D4095-3 BENDING DETAIL
(MAKE FROM D4095-3F)

WORK ORDER CHANGE
PROCEDURE CHANGE

Dart Aerospace Ltd

W/O: STEP
DATE

Part No:

2011-10-31

DES.		DART AEROSPACE USA, INC	
DRAW.		KENT, WA	
CHECKEL	NO	DRAWING NO.	REV. B
MFG. APPR.	NO	D4095	SHEET 4 OF 8
APPROVED	NO	TITLE	SCALE
DE APPR.	NO	WEARPLATE	NTS
DATE 11.10.18		COPYRIGHT © 2010 BY DART AEROSPACE USA, INC.	
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CHANGES

	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

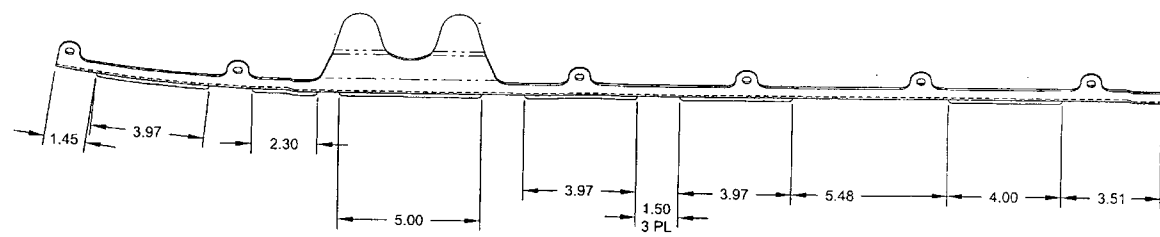
NCR:

WORK ORDER NON-CONFORMANCE (NCR)

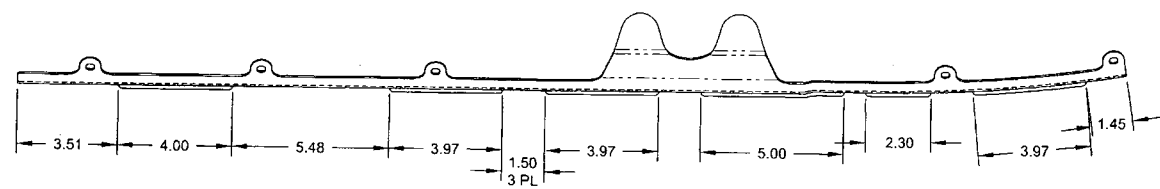
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

03479



D4095-1 WELDING DETAIL 



D4095-3 WELDING DETAIL 

RELEASED
2011-10-31
M

DESIGN		DART AEROSPACE USA, INC	
DRAWN	XDF	KENT, WA	
CHECKED	<i>10</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>10</i>	D4095	SHEET 5 OF 8
APPROVED	<i>10</i>	TITLE	SCALE
DE APPR.	<i>10</i>	WEARPLATE	NTS
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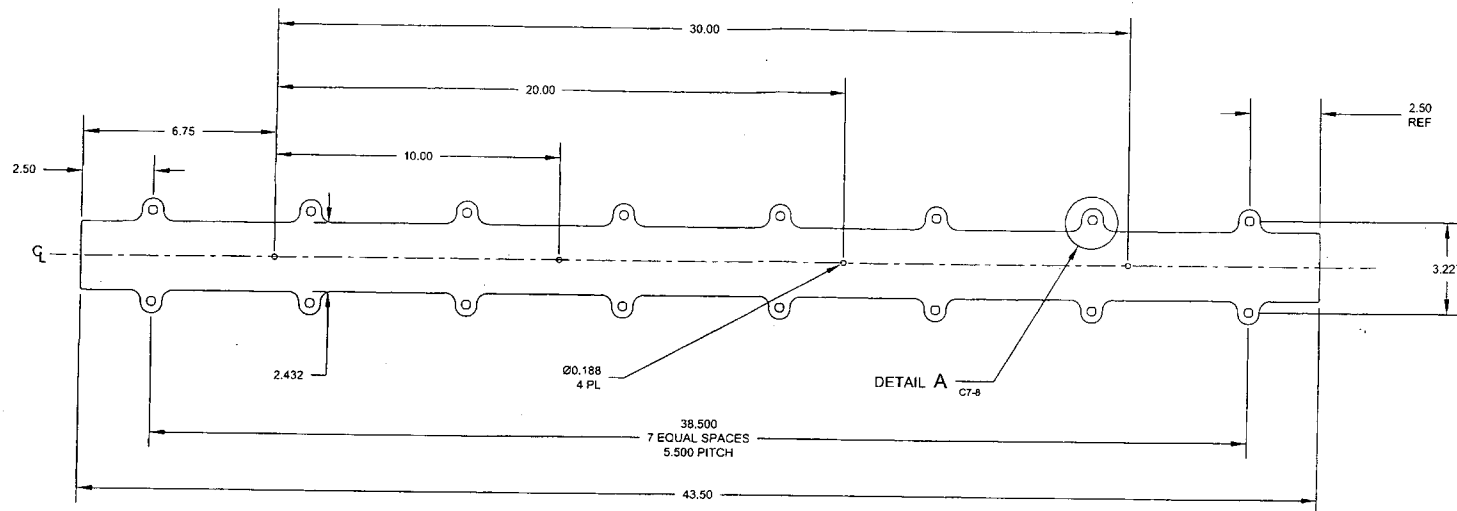
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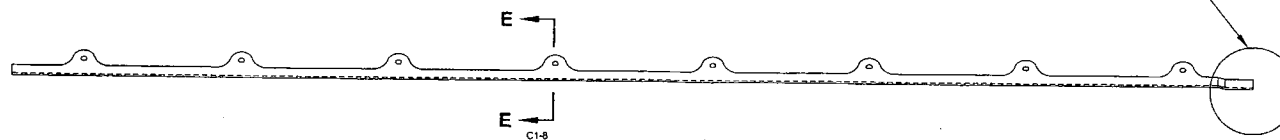
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8347B



D4095-5F FLAT PATTERN



D4095-5 BENDING DETAIL
(MAKE FROM D4095-5F)

RELEASED
2011-10-31
ND

DESIGN		DART AEROSPACE USA, INC	
DRAWN	XDF	KENT, WA	
CHECKED	110	DRAWING NO.	REV. B
MFG. APPR.	110	D4095	SHEET 6 OF 8
APPROVED	110	TITLE	SCALE
DE APPR.	110	WEARPLATE	NTS
DATE	11.10.18	<small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE, LTD.</small>	

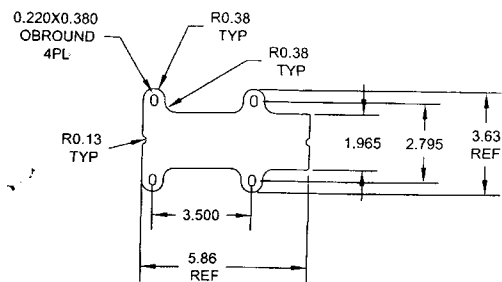
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

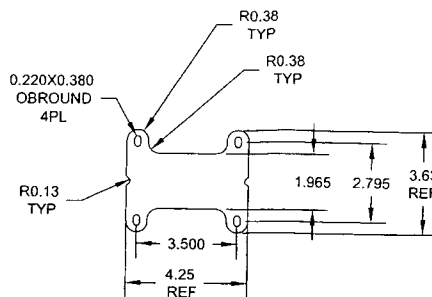
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

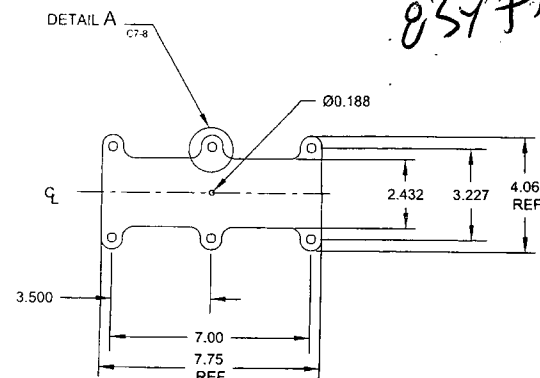
NOTE: Date & initial all entries



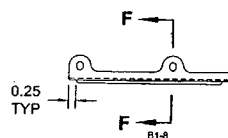
D4095-7F FLAT PATTERN 1



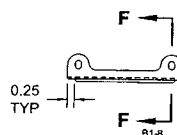
D4095-9F FLAT PATTERN 1



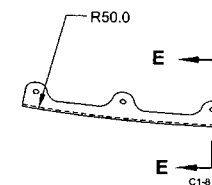
D4095-11F FLAT PATTERN 1



D4095-7 LONGITUDINAL BEND
(MADE FROM D4095-7F)



D4095-9 LONGITUDINAL BEND
(MADE FROM D4095-9F)



D4095-11 BENDING DETAIL
(MAKE FROM D4095-11F)

DESIGN		DART AEROSPACE USA, INC	
DRAWN	XDF	KENT, WA	
CHECKED	140	DRAWING NO.	REV. B
MFG. APPR.	140	D4095	SHEET 7 OF 8
APPROVED	140	TITLE	SCALE
DE APPR.	140	WEARPLATE	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

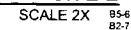
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

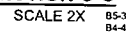
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

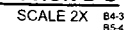
83479



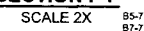
RELEASE
2011-10-31
MD



APPLY 2 LAYERS OF
2059B HARDCOAT WELDS
TO WITHIN 0.25 OF
WEARPAD ENDS
0.188 TO 0.250 THICK



— APPLY 2 LAYERS OF
2059B HARDCOAT WELDS
TO WITHIN 0.25 OF
WEARPAD ENDS
0.188 TO 0.250 THICK



APPLY 2 LAYERS OF
2059B HARDCOAT WELDS
TO WITHIN 0.25 OF
WEARPAD ENDS
0.188 TO 0.250 THICK

DESIGN		DART AEROSPACE USA, INC	
DRAWN	XDF	KENT, WA	
CHECKED	10	DRAWING NO.	REV. E
MFG. APPR.	10	D4095	SHEET 8 OF 8
APPROVED	10	TITLE	SCALE
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries